

■ **THE CHALLENGE:** The U.S. has a long history of supporting human rights, but the U.S. has not always been consistent in its approach. The U.S. has often been criticized for supporting authoritarian regimes in the name of stability and democracy. The U.S. has also been criticized for supporting human rights abuses in the name of national security. The U.S. has a responsibility to lead by example and to support human rights in a consistent and principled manner.

■ **THE SOLUTION:** The U.S. should adopt a human rights approach that is based on the principles of democracy, human rights, and the rule of law. The U.S. should support human rights in all of its foreign policy decisions, and it should hold all countries accountable for human rights abuses. The U.S. should also support human rights through economic and development assistance, and it should work to address the root causes of human rights abuses.

■ **THE FUTURE:** The U.S. has a responsibility to lead by example and to support human rights in a consistent and principled manner. The U.S. should work to build a world that is based on the principles of democracy, human rights, and the rule of law. The U.S. should work to address the root causes of human rights abuses, and it should work to ensure that all people have the opportunity to live in a free and democratic society.

Thursday, November 04, 2010 1:07:20 PM

**Accept**

[illegible]**Setup Start**[illegible]

**Stop**

**0-9**

**Start Date:** 11/4/2010      **Start Qty:** 40.00

**Required Date:** 11/25/2010      **Req'd Qty:** 40.00

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

[illegible]

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_

Date: 10-11-04

**Tooling:**

Date:

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

...the ...

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63589**

Thursday, November 04, 2010 1:07:20 PM

Page 2

Item ID: D2741

Accept

Setup Start

Revision ID:

Stop

Item Name: Blade, 350 Skidtube

Start Date: 11/4/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SL 10/12/21

(40)

Memo

0.00

140



Small Fab

Small Fab

Small Fab

Memo

1-Deburr 2-Bend per Dwg D2741

0.00

0.00

SO 10/01/03

(40)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Subs

0.00

count  
(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63589**

Thursday, November 04, 2010 1:07:20 PM

Page 3

Item ID: D2741

Accept

Setup Start

Revision ID:

Stop

Item Name: Blade, 350 Skidtube

Start Date: 11/4/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 40.00




Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Outsource1	Outsource process - Heat Treat	0.00							
	Memo	0.00							
	Issue P/O: 13196 <input type="checkbox"/> Harden material as per Dwg D2741 <input type="checkbox"/> Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) <input type="checkbox"/> Min. Yield Tensile Strength = 141 ksi <input type="checkbox"/> Test report or Certification required								
170  Packaging	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Memo	0.00							
	Ensure Test report or Certification attached								
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

C2 11/01/04 40

Per 11/13/13 C40

C40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 63589**

Thursday, November 04, 2010 1:07:20 PM



Page 5

Item ID: D2741

Accept



Setup Start



Revision ID:

Stop



Item Name: Blade, 350 Skidtube

Start Date: 11/4/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40.0 11/01/17

220

Identify as per dwg &amp; Stock Location: 466

0.00



Packaging

Memo

0.00

Packaging

11/01/18 (40)

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18

mf  
11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 04, 2010 1:07:24 PM

Page 1

Work Order ID: 63589

Parent Item: D2741

Parent Item Name: Liade, 350 Skidtube

Start Date: 11/4/2010

Required Date: 11/25/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: D 00.11.15 ☐ Removed P/O turning - in house process ☐ EC  
 IPP Rev: E 06-03-20 As Per Rev C JLM  
 IPP Rev: F ☐ 06.04.20 ☐ Added grinding after heat treating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NB0.500X03.00 0		Purchased	No			100	f	28.7250	1.1541	48.59368			



4130 Bar 0.500 x 3.00



Location	Loc Qty	Loc Code
MAT	4.725	
115686	4.725	
MAT034	24	
114044	24	

116179

48.5936<sup>88</sup> J.A 10/12/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

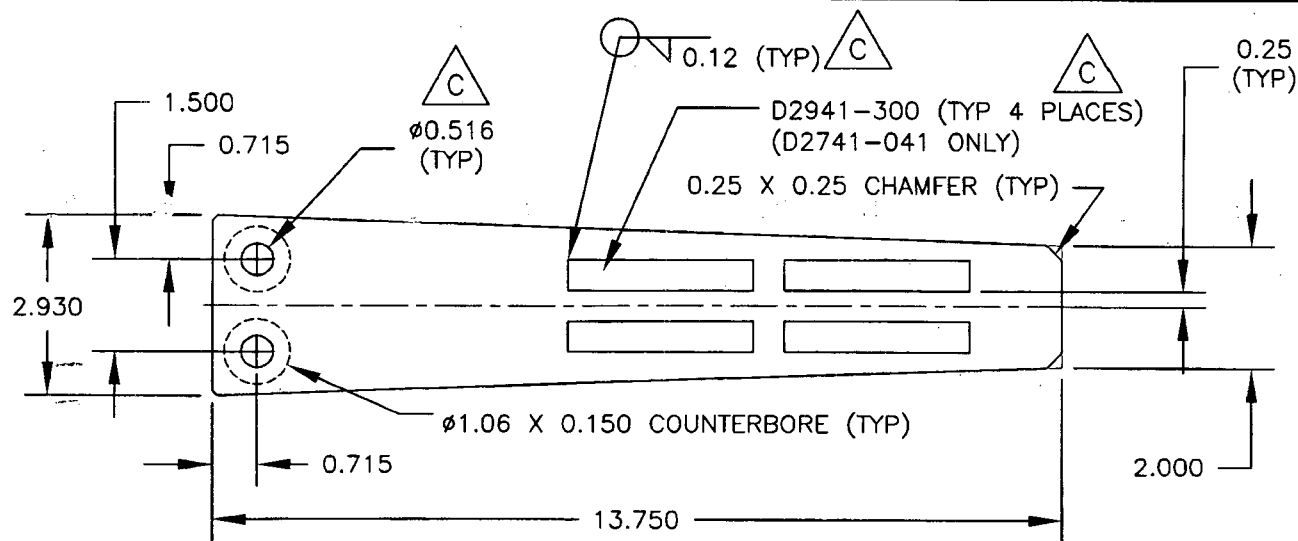
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

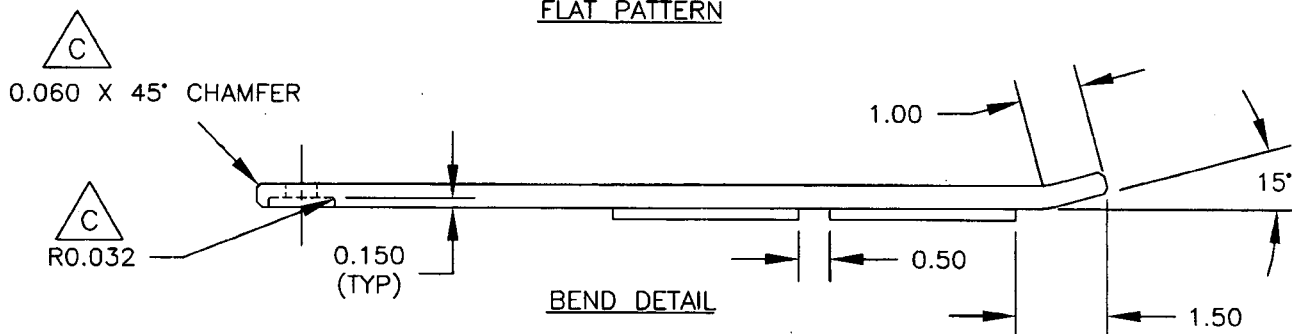
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* **NOTE:** Date & initial all entries

RELEASED  
86-02-07



### FLAT PATTERN



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63589

D2741 BLADE

- 1) MATERIAL: AISI 4130 STEEL 0.375 THICK  
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)  
MIN. YIELD TENSILE STRENGTH = 141 ksi
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.030 TO 0.060
- 6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.  
REMOVE POWDER COAT FROM SURFACE OF D2941-300
- 7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

DESIGN 94		DRAWN BY 94		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2741		REV. C SHEET 1 OF 1	
DATE 06.01.12		TITLE BLADE		SCALE 1:3	
A	98.04.16	NEW ISSUE			
B	98.09.01	CHANGE C'SINK TO C'BORE			
C	06.01.12	LARGER HOLE, ADD RADIUS AND CHAMFER ADD -0.417 ±0.43 OPTIONS			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13196

Purchase Order Date 1/04/11

PO Print Date 1/04/11

Page Number 1 of 1

Order From :

VC-MET004

METCOR INC.  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC J7R 5A8  
CA

Contact Name

Vendor Phone

450 473 1884

Vendor Fax

450 491 5498

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
12/11/04

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	63589	D2741 BLADES	1/14/11 Yes	40.00	Purolator ground	\$8.7500	\$350.00

Special Inst:

HARDEN MATERIAL AS PER DWG  
D2741 REV. C  
B63589  
MIN.ULTIMATE TENSILE  
STRENGTH = 152 KSI  
MIN.YIELD TENSILE STRENGTH =  
141 KSI  
(34-40 HRC)

PO Total:

\$350.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date:

1/04/11

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Recu de Livraison

Order	Shipper	Shipping Seq.
163588	1	48002

Shipped Complete

**Customer**      **215**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

**Shipped To:**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO13196		4130	2011/1/5	

Quantity	Part No. / Part Name / Part Description	Pounds
40	D2741 BLADE REV: C B63589 2 BOITE DE BOIS	140,

Container Type	# Of Containers	Container Comments
BOITE DE BOIS	2	

CERTIFICAT REQUIS

<b>PACKING</b>	
----------------	--

Quantity Shipped: 40  
Pounds Shipped: 140,00  
Quantity Remaining: 0  
Pounds Remaining: 0,00

CERTIFICAT REQUIS

Quantity Shipped: 40

Pounds Shipped: 140,00

Signature:

Date:

Shipped ON: 2011/01/11

## Rapport d'inspection

Order	Load
163588	1

Customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

Shipped To:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
PO13196		4130		

### PROCESSING SPECIFICATIONS

SEL HARDEN

HARDEN AND TEMPER

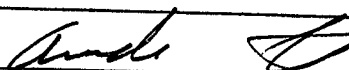
SAE AMS 2759/1 REV.E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	34 - 40 HRC	40	38 - 40 HRC
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI

Quantity	Weight	Part Number / Part Description
40	140	D2741 BLADE REV: C B63589 2 BOITE DE BOIS

### COMMENTS

INSPECTOR:



DATE: 2011-01-11

**METCOR INC.**560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

**Certification**

Order	Load
163588	1

Customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

Shipped To:

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

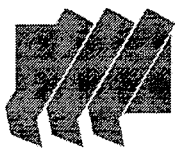
Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
PO13196		4130		

**PROCESSING SPECIFICATIONS**SEL HARDEN  
HARDEN AND TEMPER  
SAE AMS 2759/1 REV.E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	34 - 40 HRC	40	38 - 40 HRC
TENSILE (KSI)	152 - 182 KSI		171 - 182 KSI

Quantity	Weight	Part Number / Part Description
40	140	D2741 BLADE REV: C B63589 2 BOÎTE DE BOIS

Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1,00 CONT. INIT.	LAVAGE		si nécessaire							
2,00 PREPARINC	COMPTAGE									
3,00 PREHEAT 1	1000	1:00 1:30	air			133				
4,00 SEL HARDE	1575	0:40	SEL		BRINE	106				
5,00 WASH	150	0:30	soap							
6,00 SNAP TEMP	400	2:00	air			609				
7,00 SANDBLAS			Sablage							
8,00 DIST INSP										



# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

## Certification

Order	Load
163588	1

Customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

Shipped To:

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

1

ON K6A 1K7

Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
9,00 TEMPER	875 +/-10°F	4 hrs	air			638				
10,00 HARDN INS										
11,00 SANDBLAS			Sablage							
12,00 HUILAGE			huile							
13,00 FINAL INSP							01-11-2011			01-11-2011

### COMMENTS

ALL THE HEAT TREATMENT PROCESSING PERFORMED ON THIS ORDER WAS ACCOMPLISHED USING HEAT TREATMENT EQUIPEMENT THAT MEETS THE REQUIREMENTS OF AMS 2750. ALL THE HEAT TREATMENT OPERATIONS WERE ACCOMPLISHED IN ACCORDANCE WITH THE REQUESTED/REQUIRED HEAT TREATMENT SPECIFICATION AND ALL REQUIRED VERIFICATIONS TEST HAVE BEEN PERFORMED AND DOCUMENTED. NO UNAUTHORIZED CHANGES OR DEVIATIONS TO REQUIRED HEAT TREATMENT SPECIFICATIONS OR PROCEDURES HAVE BEEN PERFORMED.

APPROVED BY:

*Jonathan Rozon*

DATE: 2011-01-11

We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.

